

Date: Monday, 1/16/2006 4:18:26 PM  
User: Kim Johns  
Order: CU-DJH

Dart Aerospace Ltd.

## Process Sheet

Customer: U-DAR001 Dart Helicopters Services  
Job Number: 25516  
Estimate Number: 10469  
P.O. Number: 10469  
This Issue: 1/16/2006 S.O. No.:  
Prsht Rev.: NC  
First Issue: 1/16/2006 Type: LANDING GEAR  
Previous Run: 24866  
Written By: \_\_\_\_\_  
Checked & Approved By: \_\_\_\_\_  
Comment: Est. A 05.10.20 New Issue KJ/EC

Drawing Name: MID TUBE ASSEMBLY  
Part Number: D3391023  
Drawing Number: D3391 REV C1  
Project Number: N/A  
Drawing Revision: C1  
Material: \_\_\_\_\_  
Due Date: 2/13/2006 Qty: 3 Um: Each

### Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

D25001100

Skidtube Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)  
SKIDTUBE EXTRUSION

Pick:

Qty	Part Number	Description	Batch
1	D2500-1-100	Extrusion	B24593

Batch

2.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

- 1-Cut tube to finish length as per Dwg D3391
- 2-Identify as D3391-023
- 3-Drill pilot holes using DT8796 as per Dwg D3391
- 4-Open float bag holes to Ø0.250" as per Dwg D3391 using DT8796D visual aid Jig
- 5-C'sink float bag holes as per Dwg D3391
- 6-Open remaining holes to Ø0.375"
- 7-Remove .030" from Fwd indexing Ridge as per Dwg D3391
- 8-Remove indexing ridge on Fwd & Aft end of skidtube as per Dwg D3391
- 9-Deburr
- 10-Drill #30 pilot holes using wearplate Jig DT8217/Identify Ø0.208" holes with paint marker
- 11-Open wearplate holes of D3391-023 assembly detail section G-G to Ø0.208" (14 holes) as per Dwg D3391
- 12-Open wearplate holes of D3391-023 assembly detail section H-H to Ø0.250" and c'sink (20 holes) as per Dwg D3391
- 13-Open .375" holes to .438"
- 14-Deburr and blow out all chips from inside tube